

B



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3914-041
Job Sheet 197690



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/12/19

Job Tracking No:

Due Date: 7/26/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 17246

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	7/26/19		0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		MAL
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	7/26/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS
							QC 9 - 43		43
							QC 9 - 50		9-89
							QC 9 - 9		
120	QC 5	1 pcs	7/26/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		DAS
							QC 5 - 49		43
							QC 5 - 51		9-89
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
130	Powdercoat - 1 Black Sand - B4B	1 pcs	7/26/19		0.00	0.40	Powdercoat - 1 - B4B		
							Powdercoat - 2 - B4B		
							Powdercoat - 3 - B4B		

START: 8:30 AM J.300 Finish: 9:00

Plex 7/12/19 2:50 PM Dart.Renwick.Jennife

135 QC 3	1 pcs	7/26/19	0.00 0.00	Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	ML 19-8-2
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
140 Handfinish - 3-1 - WingWalk-B4B	1 pcs	7/26/19	0.00 0.80	Handfinish - 3 - 1 - B4B	ML 19-8-2
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
150 QC 3	1 pcs	7/26/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
160 Packaging 3-1 - Stock - B4B	1 pcs	7/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 -	

DAS
15
9-89

DAS
40
AUG 02 2019 9-89

					B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	14.8-2
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170	QC 21 - SA	1	7/26/19	0.00	0.00	QC 21 - SA - 21
		pcs				QC 21 - SA - 70
						QC 21 - SA - 53
Part Op 100 - (Weld per dwg A/R S.S. rod Batch: <u>M139015</u>) - assemble ribs, weld as per dwg D3914 using DT9607A 2- weld Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh*** 110 - QC9- Inspect visual per QSI004- Fusion Welds 120 - QC5- Inspect part completeness to step on W/O 130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat*** 135 - QC3- Inspect Part Finish 140 - Wing Walk as per dwg QSI005 4.4 Batch _____ 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label *** 150 - QC3- Inspect Part Finish 160 - Identify as per dwg & Stock Location: _____ 170 - QC21- Final Inspection - Work Order Release						

NY # 011018

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S188852
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S197816
D3914-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S190856
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	S193147
D4018-5	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	S199434
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	100-Large Fab - Basket - 1	S101243
D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	S172801
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	S109810

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	46	0
	D3914-1	2	6	0
	D3914-7	2	8	0
	D4016-3	3	80	0
	D4018-5	9	11	0
	D4020-5	1	4	0
	D4021-3	1	30	0
	D4035-043	2	14	0

Part Specifications	
Specifications could not be found.	

Plex 7/12/19 2:50 PM Dart.Renwick.Jennifer



Container No: S199906



Part: D3914-041

Job No: 197690

Serial No/Batch: S199906

Revision: A/D

Inspector:

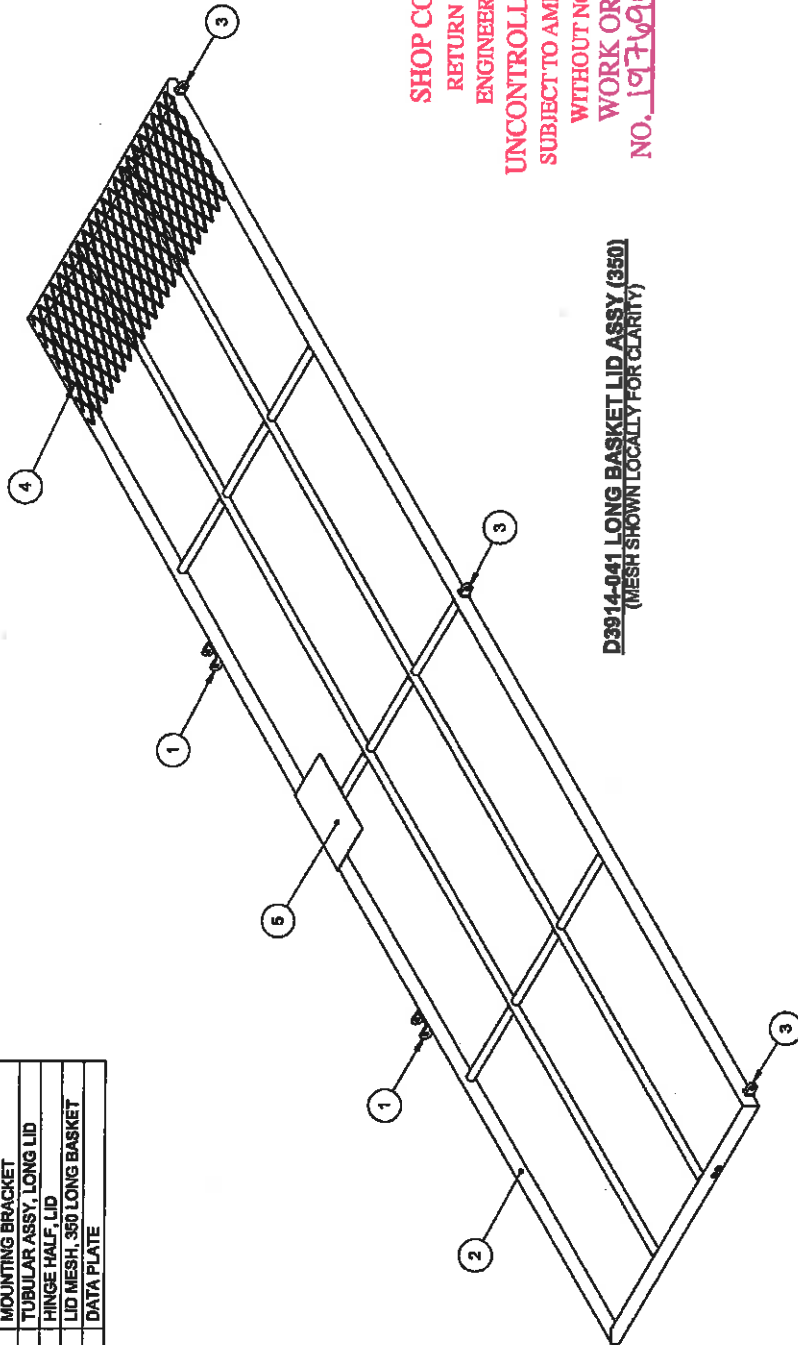
Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 07/23/19

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	1	D3914-101	TUBULAR ASSY, LONG LID
3	3	D4018-3	HINGE HALF, LID
4	1	D4020-5	LID MESH, 350 LONG BASKET
5	1	D4021-3	DATA PLATE



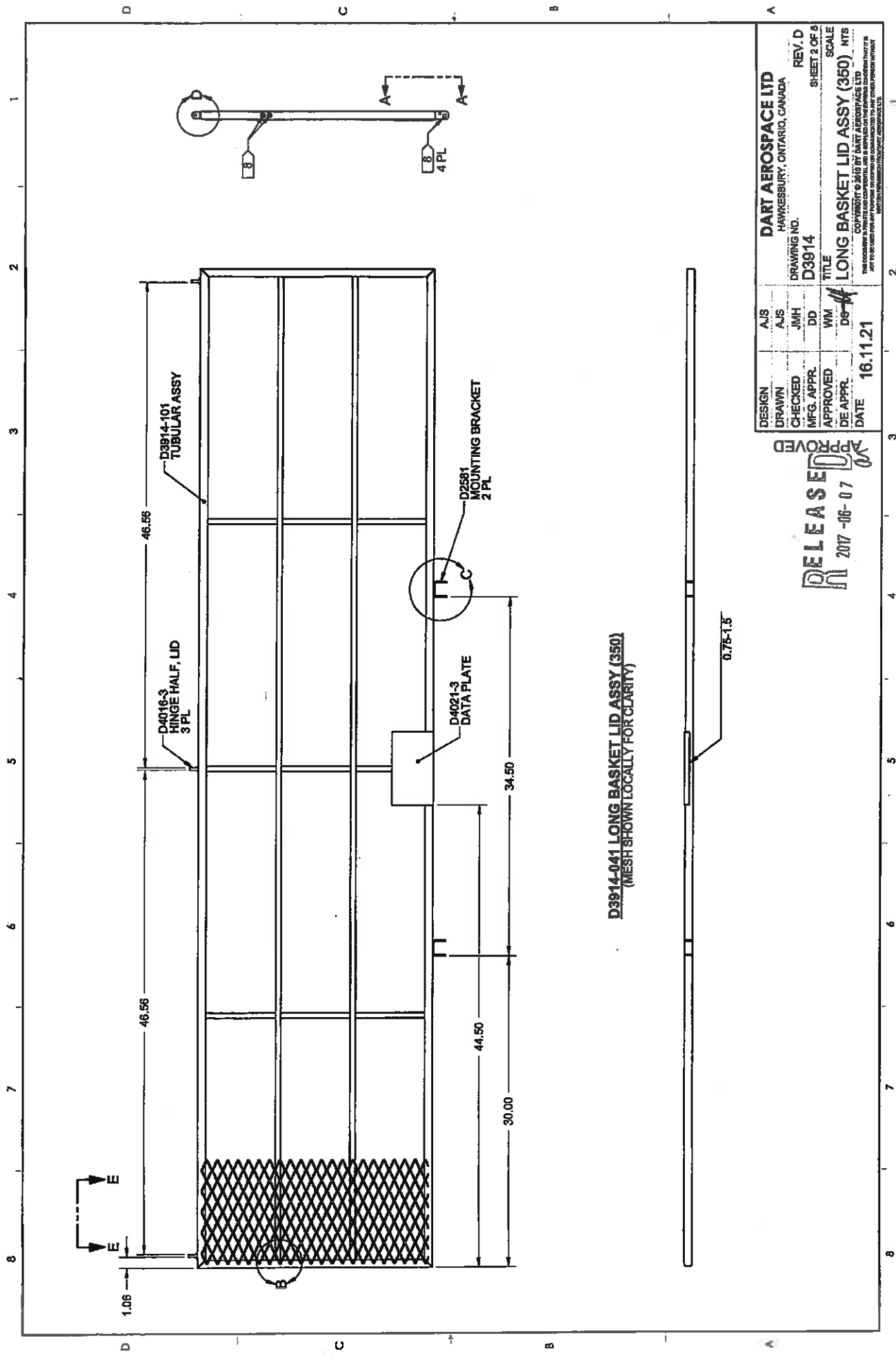
D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197690

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANOTEX (4.3.6.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
 - 7) WEIGHT: 22.35 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004
 - 10) MASK THIS AREA PRIOR TO FINISH

RELEASED
2017-06-07
EWN 17-530

D	SHEET 1: UPDATED NOTE 6 ADDED NOTE 10, D2728-3 DELETED, SHEET 2: SECTION AND VIEW LETTERS UPDATED, ADDED VIEW E-E (PART 10-416)	AJS	18.11.21
C	REMOVED D4084-210, DELETED AND REPLACED BY DART QSI 005 4.4. REASON: PRO FORMA NO LONGER OFFERED.	AJS	13.03.13
B	REMOVED D4084-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D3914-007-2 REV. C AND D3914-007-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	JMH		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS		
DATE	16.11.21		
DART AEROSPACE LTD HAINESBURY, ONTARIO, CANADA DRAWING NO. D3914 TITLE LONG BASKET LID ASSY (350) SCALE 1 OF 5 SHEET 1 OF 5 NTS COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT REMAINS THE PROPERTY OF DART AEROSPACE LTD AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING.			

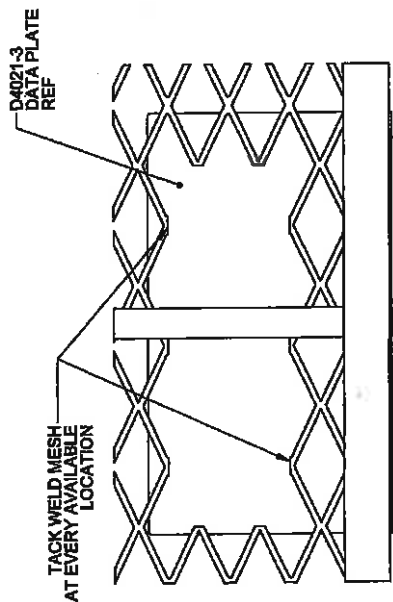


D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

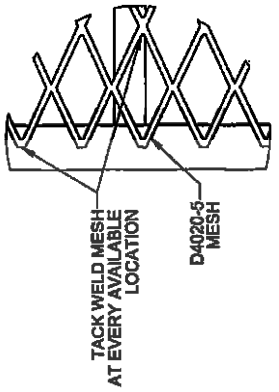
DESIGN	AJS	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	JMH	DRAWING NO. D3914
MFG. APPR.	DD	REV. D SHEET 2 OF 8
APPROVED	WM	TITLE LONG BASKET LID ASSY (350) NTS
DE APPR.	DS-44	SCALE
DATE	16.11.21	COPYRIGHT © 2016 BY DART AEROSPACE LTD

RELEASED
2017-06-07
APPROVED

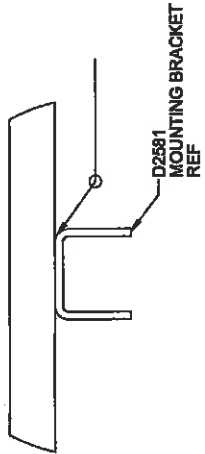
1 2 3 4 5 6 7 8



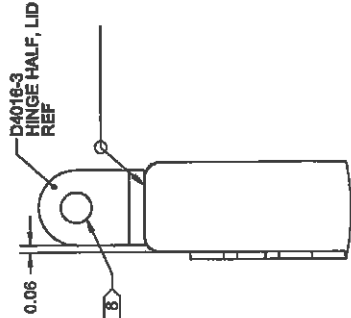
VIEW A-A
SCALE 4X



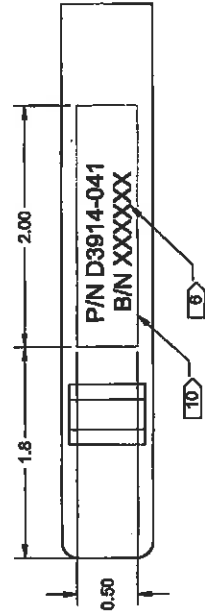
DETAIL B
SCALE 4X



DETAIL C
SCALE 4X
2 PL



DETAIL D
SCALE 8X
3 PL



VIEW E-E
SCALE 8X

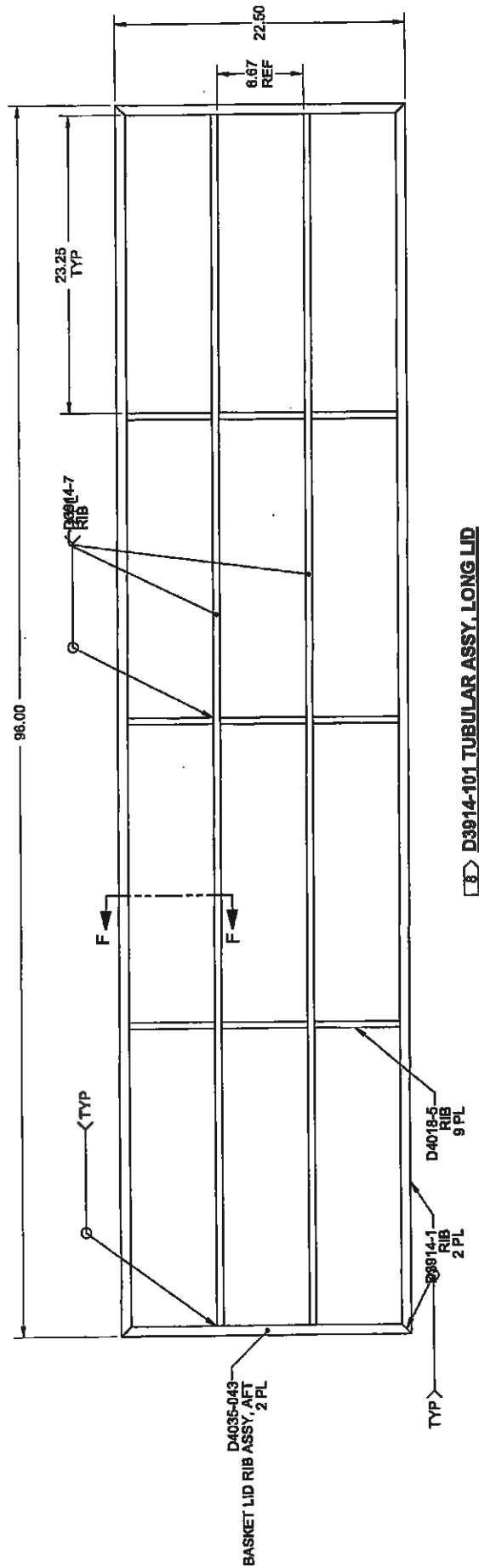
DESIGN	AJS	AJS	DART AEROSPACE LTD
DRAWN	AJS	DART AEROSPACE LTD	HAWKESBURY, ONTARIO, CANADA
CHECKED	JMH	DRAWING NO.	D3914
MFG. APPR.	DD	TITLE	LONG BASKET LID ASSY (350) NTS
APPROVED	WM	SCALE	SHEET 3 OF 6
DE APPR.	DS	DATE	16.11.21

RELEASED
2017-06-07
APPROVED

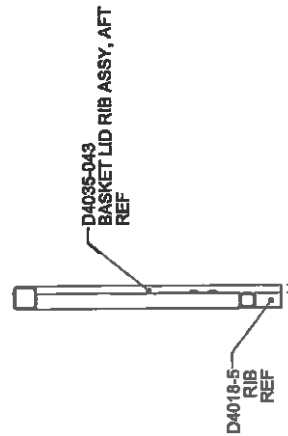
REVISIONS
REV. D
SHEET 3 OF 6

LONG BASKET LID ASSY (350) NTS
COPYRIGHT © 2010 BY DART AEROSPACE LTD
ALL RIGHTS RESERVED
NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	8	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



8 D3914-101 TUBULAR ASSY, LONG LID



SECTION A-A
SCALE 2X

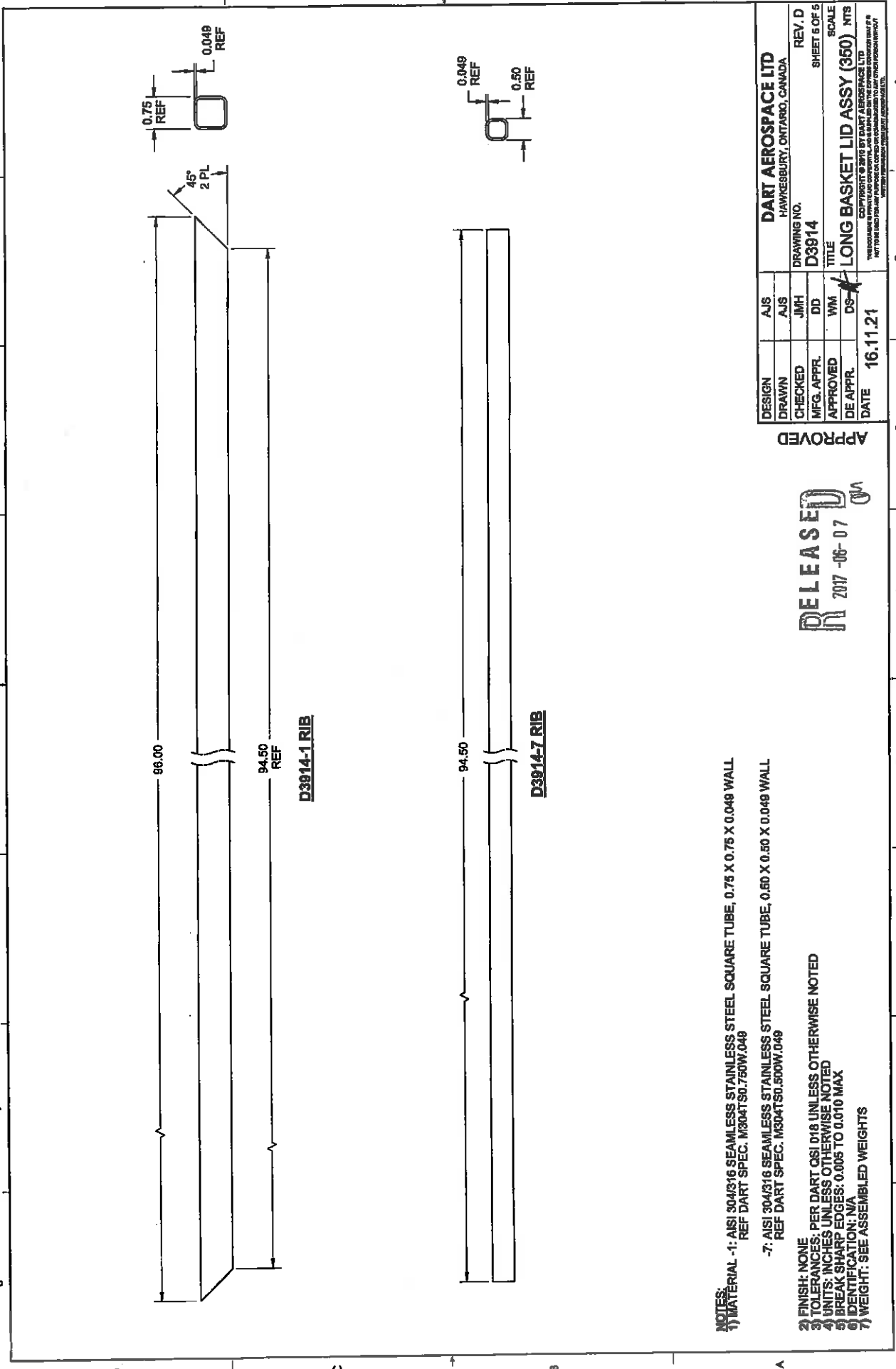
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS 0.06 FOR D3914-101
 - 9) WELD PER DART QSI 004

DESIGN	AJS	AJS	DART AEROSPACE LTD
DRAWN	AJS	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	JMH	JMH	DRAWING NO. D3914
MFG. APPR.	DD	DD	REV. D SHEET 4 OF 8
APPROVED	WM	WM	TITLE
DE APPR.	DE	DE	LONG BASKET LID ASSY (350) NTS
DATE	16.11.21	16.11.21	SCALE

RELEASED
2017-06-07

COPYRIGHT © 2016 BY DART AEROSPACE LTD
THIS DOCUMENT IS UNCLASSIFIED UNLESS INDICATED OTHERWISE
NOT TO BE USED FOR ANY PURPOSES UNLESS SO INDICATED TO DART AEROSPACE LTD

1 2 3 4 5 6 7 8



NOTES:
1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304T\$0.750W.049
-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304T\$0.500W.049

2) FINISH: NONE
3) TOLERANCES: PER DART Q81 D18 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
2017-06-07

APPROVED